

Work Order ID 125585

Wednesday, October 15, 2014 1:22:44 PM

125585

Page 1

Item ID: 41228-301-065-001

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cavity Assembly, LH

Start Date: 10/16/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/31/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date: 14-10-15

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

41228-301-065

C2

0.00

0.00

0.00

0.00

0.00

0.00

110

110

Small Fab

Small Fab

Memo

ASSEMBLE AS PER DWG

120

120

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

130

130

Packaging

Packaging

Identify as per dwg & Stock Location: _____

Packaging

Memo

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 125585***125585***

Page 2

Wednesday, October 15, 2014 1:22:44 PM

Item ID: 41228-301-065-001 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Cavity Assembly, LH
Start Date: 10/16/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 10/31/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

closed as
incomplete
write all

u 17.05.24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Page 1

Wednesday, October 15, 2014 1:22:49 PM

Work Order ID: 125585

125585

Parent Item: 41228-301-065-001

41228-301-065-001

Parent Item Name: Cavity Assembly, LH

Start Date: 10/16/14

Required Date: 10/31/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.10.03 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN4-10A		Purchased	No				Each	76.0000		4			
AN4-10A									**		<u>4</u>	<u>KC</u>	
Bolt													

Location	Loc Qty	Loc Code
CA	18	
M129682	18	
ST345	38	
M130466	38	
ST355	20	
M127815	20	

M131677
x4

15-6-23

MS20365-428	MS21044N4	Purchased	No				Each	64.0000		4			
MS20365-428									**		<u>4</u>	<u>KC</u>	
Nut													

Location	Loc Qty	Loc Code
ST315	64	
m128818	64	

15-6-23

MS21044N3		Purchased	No				Each	50.0000		4			
MS21044N3									**		<u>4</u>	<u>KC</u>	
NUT													

Location	Loc Qty	Loc Code
ST306	50	
m129541	50	

15-6-23

8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Equip/Tooling									
Handling/Pre									
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Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Wednesday, October 15, 2014 1:22:49 PM

Page 2

Work Order ID: 125585

125585

Parent Item: 41228-301-065-001

41228-301-065-001

Parent Item Name: Cavity Assembly, LH

Start Date: 10/16/14

Required Date: 10/31/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

Each

4,105.000

8

NAS1149D0463.J

WASHER

KC

15-6-23

Location

Loc Qty

Loc Code

CA

472

M129682

472

ST277

3633

16941

8

M126221

20

M127813

6

M127904

16

M128591

44

M128995

1500

M129390

2039

Each

3.0000

1

KC

15-6-23

Location

Loc Qty

Loc Code

CA

3

m129682

3

Each

0.0000

1

KC

15-6-23

41228-301-063-001

Purchased

No

41228-301-063-001

Fuel Return Cavity, LH

41228-301-071-001

Manufactured

No

Each

8.0000

1

41228-301-071-001

Reinforcement Plate

Location

Loc Qty

Loc Code

CA

8

m129682

8

DQA: _____ Date: _____



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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Wednesday, October 15, 2014 1:22:49 PM

Work Order ID: 125585

125585

Parent Item: 41228-301-065-001

41228-301-065-001

Parent Item Name: Cavity Assembly, LH

Start Date: 10/16/14

Required Date: 10/31/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

Each

1,985.000

8

NAS1149D0363.J

Washer

Location

Loc Qty

Loc Code

GA

7

124392

7

ST276

945

m123441

5

m130358

940

ST510a

1033

m128429

1033

AE89347H

Purchased

No

Each

4.0000

1

AF89347H

FITTING

Location

Loc Qty

Loc Code

CA

4

M129682

4

AE89347M

Purchased

No

Each

1.0000

1

AF89347M

Fitting

Location

Loc Qty

Loc Code

CA

1

M129682

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Transport									
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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125585

Parent Item: 41228-301-065-001

41228-301-065-001

Parent Item Name: Cavity Assembly, LH

Start Date: 10/16/14

Required Date: 10/31/14

Start Qty: 1.00

Required Qty: 1.00

AN3-7A

Purchased

No

Each

223.0000

4

AN3-7A

4

KL

Bolt

15-6-23

Location

Loc Qty

Loc Code

ST349

223

M126175

23

M128634

50

M129507

50

M129706

100

M131420
x 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

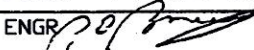
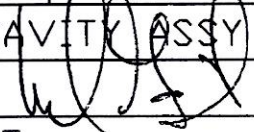
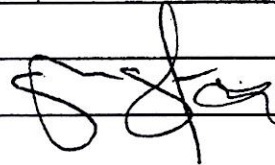
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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 01925				SHEET 1 OF 1	
	DWG NO. 41228-301-065		REV: C	PREPARED BY D. BARKER	DATE: 08/28/07	EFFECT ON DWG ☐ INC. ☒ UNINC.
	DWG TITLE: FUEL RETURN CAVITY ASSY					
APPROVED BY: ENGR 		MFG 		QC 	EFF: CURRENT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: UPDATED PARTS LIST				

**CONTROL COPY
ISSUED DATE**

SEP 04 2007

 14-10-15
125585

12	R	MS21044N3	4	4	NUT				
10	R	601.1718	8	8	WASHER		NAS1149D0363J		
9	R	NAS1149D0463J	8	8	WASHER		ALT P/N AN960JD416		
			-001	-002					
F/N	TC	PART NUMBER	QTY	NAME		STOCK SIZE	MATERIAL	MATL. SPEC	ZONE
DOCUMENTS EFFECTED:						CHANGE CATEGORY		DER REVIEW REQUIRED	
☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☒ BOM						☐ MAJOR ☒ MINOR		☐ YES ☒ NO	

APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.		01834		SHEET OF 1	
DWG NO. 41228-301-065		REV: C	PREPARED BY D. BARKER	DATE: 05/18/07	EFFECT ON DWG ☐ INC. ☒ UNINC.
DWG TITLE: FUEL RETURN CAVITY ASSY					
APPROVED BY:	ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: CURRENT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: UPDATED PARTS LIST			

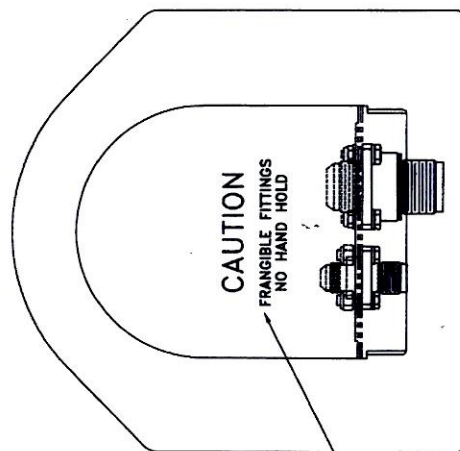
SHEET 1, PARTS LIST IS:

IS	1	1	14	20528-301-007-002	STENCIL	(B)				
	1	1	13	41228-301-071-001	REINFORCEMENT PLATE	(A)				
	4	4	12	MS20365-1032	NUT					
	4	4	11	MS20365-428	NUT					
	8	8	10	AN960JD10	WASHER					
	8	8	9	AN960JD416	WASHER					
	4	4	8	AN3-7A	BOLT					
	4	4	7	AN4-10A	BOLT					
	1	1	6	AE89347H	FITTING		AEROQUIP, JACKSON, MICH.			
	1	1	5	AE89347M	FITTING		AEROQUIP, JACKSON, MICH.			
	1	4	41228-301-063-002	R/H CAVITY						
		1	3	41228-301-063-001	L/H CAVITY					
			2	41228-301-065-002	R/H ASSY					
			1	41228-301-065-001	L/H ASSY					
			-002-001	FIND NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL. SPEC.	ZONE

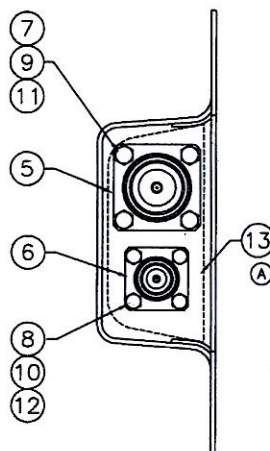
NO. REQ'D PER ASSY.		LIST OF MATERIAL									
		UNLESS OTHERWISE SPECIFIED	DRAFTSMAN	D. NELSON	5/22/95	TITLE					
			CHECK			FUEL RETURN CAVITY ASSY					
		X ± .1	STRESS			DWG. SIZE	C	SCALE	NONE		
		XX ± .03	PROL	EXOR.							
		XXX ± .010	HEAT TREAT								
		ANGLES ± 1/2	FRESH								
						Era Helicopters LLC	41228-301-065	REV.	C		

CONTROL COPY
ISSUED DATE
MAY 24 2007

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:					CHANGE CATEGORY
☐ MDL ☐ INSTALL INSTRUC ☐ FMS ☐ ICA ☒ BOM					DER REVIEW REQUIRED ☐ YES ☒ NO



14
B



41228-301-065-001 L/H ASSY
41228-301-065-002 R/H ASSY

REVISION				APPROVED	DATE
LETTER	DESIGN	DATE	DESCRIPTION		
A	DNN	9/8/95	ADDED REINFORCEMENT PLATE		
B	DNN	12/14/95	INCORPORATED E.O. B-1.	D. HAWKILL 265-96-12 P. SCHWITZ	2/27/96
				96.014	3/21/96
				96.015	3/21/96
				96.016	3/21/96
C	DNN	6/14/05	INCRP. E.O. C-1: CHANGED P/N OF ITEM #7. MINOR CHANGE - FAR 21.95		

UNINCORPORATED ECN(S)

01834, 01925,

		1	1	14	41228-301-067-002	STENCIL 20528	401-001-002			
		1	1	13	41228-301-071-001	REINFORCEMENT PLATE	A			
		4	4	12	MS20365-4032	NUT	MS21044N3			
		4	4	11	MS20365-428	NUT				
		8	8	10	AN9604B16	WASHER	601.1718			
		8	8	9	AN9603D16	WASHER	NAS1149D041035			
		4	4	8	AN3-7A	BOLT				
		4	4	7	AN4-10A	BOLT				
		1	1	6	AE89347H	FITTING	AEROQUIP, JACKSON, MICH.			
		1	1	5	AE89347M	FITTING	AEROQUIP, JACKSON, MICH.			
		1		4	41228-301-063-002	R/H CAVITY				
		1		3	41228-301-063-001	L/H CAVITY				
		2			41228-301-065-002	R/H ASSY				
		1			41228-301-065-001	L/H ASSY				
					-002-001	PRD NO.				
					PART NO.	NAME	STOCK SIZE	MATERIAL	MATL.SPEC.	ZONE

NO. REQ'D PER ASSY.

LIST OF MATERIAL

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		1			41228-300-006					
		1			41228-300-007					
					NEXT ASSEMBLY					

UNLESS OTHERWISE SPECIFIED
X ± .1
XX ± .03
XXX ± .010
ANGLES ± 1/2°

DRAFTSMAN
D. NELSON
5/22/95
CHECK
STRESS
PROL.
ENGR.
HEAT TREAT
FINISH

ERA Helicopters LLC

TITLE FUEL RETURN CAVITY ASSY				DWG. NO.	REV.
DWG. SIZE	C	SCALE	NONE		
				41228-301-065	C

PAINT STENCIL TO CONTRAST WITH BACKGROUND COLOR. PAINT MATERIAL SPECIFICATION TO MATCH USER REQUIREMENTS.

NOTE: B